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APR 03 2007

Docket No. F-8224

Ser. No. 10/823,919

AMENDMENTS TO THE CLAIMS:

Please replace the claims with the claims provided in the listing below wherein status, amendments, additions and cancellations are indicated.

1 -2. (Cancelled)

3. (New) A battery comprising:

an electrode group formed from battery electrode plates of a positive electrode and a negative electrode spirally wound with a separator interposed therebetween;

a battery case for housing said electrode group; and

at least one of the battery electrode plates being manufactured by a method comprising:

impregnating an entire porous core substrate, which forms the at least one battery electrode plate and is thin plate shaped, with an active material;

press working a first surface of said active material impregnated core substrate to form a rail shaped protrusion protruding above pressed portions and defining boundaries with said pressed portions;

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removing the active material from said rail shaped protrusion to form said rail shaped protrusion into a core substrate exposed section by applying ultrasonic vibrations to said rail shaped protrusion;

compressing said core substrate exposed section down to an identical level with said pressed portions to produce substantially true straight boundaries between said core substrate exposed section and said pressed portions wherein said substantially true straight boundaries exhibit a deviation from straight of no more than 0.2 mm; and

welding a collector lead to said core substrate exposed section.

4. (New) The battery according to claim 3, wherein said boundaries have a boundary radius in a range of 0.3mm to 0.6 mm

5. (New) The battery according to claim 3, wherein said pressed portions are pressed by a single press working using a roller having at least a 550 mm diameter producing an elongation less than 1.9%.

6. (New) The battery according to claim 5, wherein said pressed portions are pressed to approximately half a thickness.

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7. (New) The battery according to claim 6, wherein said pressed portions are pressed by applying 10 ton/cm.

8. (New) The battery according to claim 7, wherein said roller is advanced at approximate 450 mm/sec.

9. (New) The battery according to claim 8, wherein said core substrate has a lower surface opposite an upper surface in which said rail shaped protrusion is formed, the rail shaped protrusion has a thickness B which is approximately 1.1 mm extending from said lower surface to a top surface of said rail shaped protrusion, and said pressed portions have a thickness D which is approximately 0.6 mm.

10. (New) The battery according to claim 3, wherein said impregnating the entire porous core substrate before said work pressing forming said pressed portion is effected so as to produce an impregnation density variation of no more than 1.5% in said pressed portion after forming said battery electrode.

11. (New) The battery according to claim 3, wherein:

said removing the active material including removing the active material from a volume of said active material impregnated core substrate defined by said rail shaped protrusion and extending from said first surface at said rail shaped protrusion

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to an opposing second surface of said active material impregnated core substrate so as to result in 4% or less residual active material by weight in said volume of said core substrate exposed section; and

said compressing said core substrate exposed section compresses said core substrate exposed section to result in a strength of said core substrate exposed section, after said removing of said active material and said compressing, being substantially equal to a strength of said pressed portions.

12. (New) The battery according to claim 3, wherein said battery case is prismatic.

13. (New) A battery comprising:

an electrode group formed from battery electrode plates of a positive electrode and a negative electrode spirally wound with a separator interposed therebetween;

a battery case for housing said electrode group; and

at least one of the battery electrode plates being manufactured by a method comprising:

impregnating an entire porous core substrate, which forms the at least one battery electrode plate and is shaped like a thin plate, with an active material;

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press working a first surface of said active material impregnated core substrate to form a rail shaped protrusion protruding above pressed portions and defining boundaries with said pressed portions;

removing the active material from a volume of said active material impregnated core substrate defined by said rail shaped protrusion and extending from said first surface at said rail shaped protrusion to an opposing second surface of said active material impregnated core substrate to form said rail shaped protrusion into a core substrate exposed section by applying ultrasonic vibrations to said rail shaped protrusion so as to result in 4% or less residual active material by weight in said volume of said core substrate exposed section;

compressing said core substrate exposed section down to an identical level with said pressed portions to result in a strength of said core substrate exposed section, after said removing of said active material and said compressing, being substantially equal to a strength of said pressed portions, and substantially true straight boundaries being formed between said pressed portions and said core substrate exposed section after said compressing exhibit a deviation from straight of no more than 0.2 mm; and

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welding a collector lead to said core substrate exposed section.

14. (New) The battery according to claim 13, wherein said ultrasonic vibrations are applied to said rail shaped protrusion with an ultrasonic device producing an ultrasonic amplitude in a range of 25 to 50 microns.

15. (New) The battery according to claim 14, wherein said core substrate has a lower surface opposite an upper surface in which said rail shaped protrusion is formed, the rail shaped protrusion has a thickness B which is approximately 1.1 mm extending from said lower surface to a top surface of said rail shaped protrusion, said pressed portions have a thickness D which is approximately 0.6 mm, and said ultrasonic device applies said ultrasonic vibrations using a horn having a surface positioned a distance C above said lower surface which is approximately 7 to 0.8 mm.

16. (New) The battery according to claim 15, further comprising applying vacuum suction devices to said lower surface of said core substrate opposing said ultrasonic device to capture active material dislodged by said ultrasonic vibrations.

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17. (New) The battery according to claim 16, wherein said impregnating the entire porous core substrate before said work pressing forming said pressed portion is effected so as to produce an impregnation density variation of no more than 1.5% in said pressed portion after forming said battery electrode.

18. (New) The battery according to claim 13, wherein said impregnating the entire porous core substrate before said work pressing forming said pressed portion is effected so as to produce an impregnation density variation of no more than 1.5% in said pressed portion after forming said battery electrode.

19. (New) The battery according to claim 13, wherein said pressed portions are pressed to approximately half a thickness by applying 10 ton/cm using a roller advanced at approximate 450 mm/sec.

20. (New) The battery according to claim 13, wherein said battery case is prismatic.